

ASAP

Work Order ID 97452

97452

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March-20-13 8:10:38 AM

Item ID: D4316-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tube Assembly
 Start Date: 2/20/13 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 3/06/13 Req'd Qty: 8.00 *8* Customer:

Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4316	A								
100		0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- Cut D4316-3 as per dwg D4316 2- Drill holes and chamfer holes as per dwg D4316 3- Remove identification marks and deburr								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Weld per dwg A/R S.S. rod Batch: <u>M100357</u>	0.00							
120									
Large Fab	Memo	0.00							
Large Fab	Grind weld flush as per dwg D4316								

⑧ 12-13-20

⑧ 13-03-20 D4316 09

⑧ 13-3-21

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 Required Date: 3/06/13 Req'd Qty: 8.00 ***8*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				(8)	13-03-21		DAS 09 2-09
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(8)	13-03-21		DAS 09 2-09
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo Rusty	0.00 0.00					143/3/21	(8)	

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 13-03-22
WKF
13-3-22

Picklist Print

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Work Order ID: 97452

Parent Item: D4316-041

Start Date: 2/20/13

Required Date: 3/06/13

Parent Item Name: Tube Assembly

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev:A 11.02.02 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 Bushing		Manufactured	No			120	Each	182.0000	2	16		13-3-20	

Location Loc Qty Loc Code

WA004

182

66489

1

79213

1

83464

7

86550

20

88236

98

89780

11

90786

44

16

M304TS0.750W.049

Purchased

No

304 SQ Tube .75x.75x.049W

100

f

707.1584

1.04

8.7578947

EL

13-3-20

Location Loc Qty Loc Code

MAT017

500.5358

124492

500.5358

8.75

WA006

206.6226374

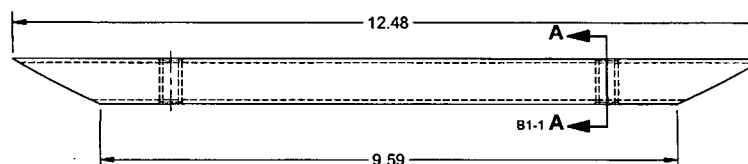
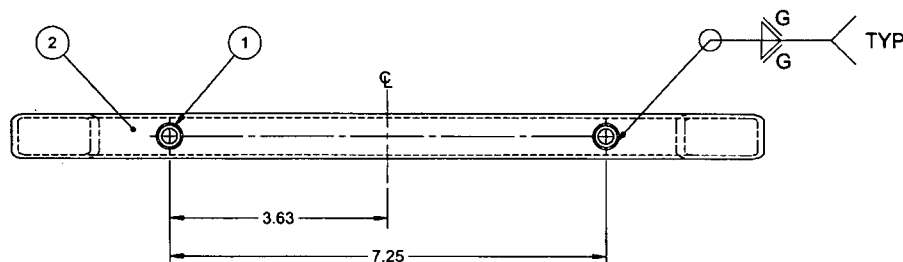
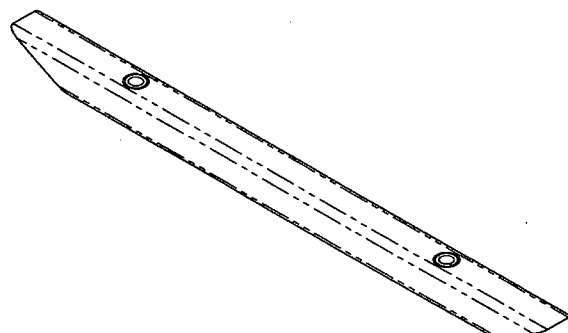
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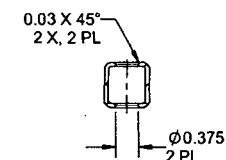
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153.202486

ITEM	QTY	P/N	DESCRIPTION
	X	D4316-041	TUBE ASSEMBLY
1	2	D3759-1	BUSHING
2	1	D4316-1	SUPPORTING RIB



D4316-041 TUBE ASSEMBLY



SECTION A-A⁸³⁻¹

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - WEIGHT: 0.55 lbs

*also
D4316-041*

RELEASED
2011-03-02
JP

A	NEW ISSUE	AJS	11.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4316** REV. A
SHEET 1 OF 1
TITLE **TUBE ASSEMBLY** SCALE NTS

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